Work Order ID 62073

Wednesday, September 15, 2010 3:15:23 PM

Item ID: D2803-042 **Accept** **Setup Start**

Revision ID: **Stop**

Item Name: Bracket Assembly

Start Date: 9/15/2010 **Start Qty:** 2.00 **Cust Item ID:**

Required Date: 9/22/2010 **Req'd Qty:** 2.00 **Customer:**

Reference:

Approvals: **Process Plan:** ✓ **Date:** 10-9-10 **Tooling:** _____ **Date:** _____ **Run Start**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
D2803	Rev B								
100	Small Fab	0.00							
Small Fab	**Memo**	0.00							
Small Fab	Press D2805-2 into arm as per Dwg D2803								
110	QC5- Inspect part completeness to step on W/O	0.00							
QC	**Memo**	0.00							
Quality Control									
120	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
Powdercoat	**Memo**	0.00							
Powder Coating	START TIME: 1:45 ☐OVEN TEMPERATURE: 320 ☐FINISH TIME: 2:15								

EJS 10/09/16 (2)

110: 8 10/09/16 (2)

120: M115291 BL 10-9-20. (2) ϕ.

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

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QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC3- Inspect Part Finish	0.00	10/9/21			2	0		
QC	**Memo**	0.00							
Quality Control									
140	Small Fab	0.00							
Small Fab	**Memo**	0.00							
Small Fab	Press D2809 into arm as per Dwg D2803								
150	Small Fab	0.00							
Small Fab	**Memo**	0.00							
Small Fab	Assemble as per Dwg D2803.								

10/09/21 (2)

10/09/21 (2)

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Run Start **Stop**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 QC Quality Control	QC5- Inspect part completeness to step on W/O	0.00 S 10/09/21				(+2)			
	Memo	0.00							
170 Packaging Packaging	Identify as per dwg & Stock Location: 148	0.00				10/9/22	SP	RW	
	Memo	0.00							
180 QC Quality Control	QC21- Final Inspection - Work Order Release	0.00					10/09/23		
	Memo	0.00							

MF 10-9-23

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

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Picklist Print

Wednesday, September 15, 2010 3:15:27 PM

Work Order ID: 62073

Parent Item: D2803-042

Parent Item Name: Bracket Assembly

Start Date: 9/15/2010 **Required Date:** 9/22/2010

Start Qty: 2.00 **Required Qty:** 2.00

Comments: IPP F□05.03.30□MS21043-3 was MS21042L3□KJ/JLM□

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2803-2		Manufactured	No			100	Each	4.0000	1	2			
Bracket													
				Location			**Loc Qty**		**Loc Code**				
				ST148			4						
					46611		2			2			
					56187		2						
D2805-2		Manufactured	No			100	Each	10.0000	1	2			
Stop													
				Location			**Loc Qty**		**Loc Code**				
				ST024			10						
					46736		2						
					58528		8			2			
NAS1515H3		Purchased	No			100	Each	34.0000	4	8			
Washer													
				Location			**Loc Qty**		**Loc Code**				
				ST277			34						
					111268		34			8			
AN3C16A		Purchased	No			150	Each	59.0000	2	4			
Bolt													
				Location			**Loc Qty**		**Loc Code**				
				ST352			59						
					111193		9						
					111425		50			4			

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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Picklist Print

Wednesday, September 15, 2010 3:15:27 PM

Work Order ID: 62073

Parent Item: D2803-042

Parent Item Name: Bracket Assembly

Start Date: 9/15/2010 **Required Date:** 9/22/2010

Start Qty: 2.00 **Required Qty:** 2.00

D2809 Bushing	Manufactured	No	150	Each	43.0000	1	2	10/09/21

Location	Loc Qty	Loc Code
ST025	43	
34035	12	
46438	1	
47733	30	2

MS21043-3 Nut	Purchased	No	150	Each	2,643.000	2	4	10/09/21

Location	Loc Qty	Loc Code
FG	76	
103691	76	
ST301	2567	
109147	4	
111383	46	
112314	2517	4

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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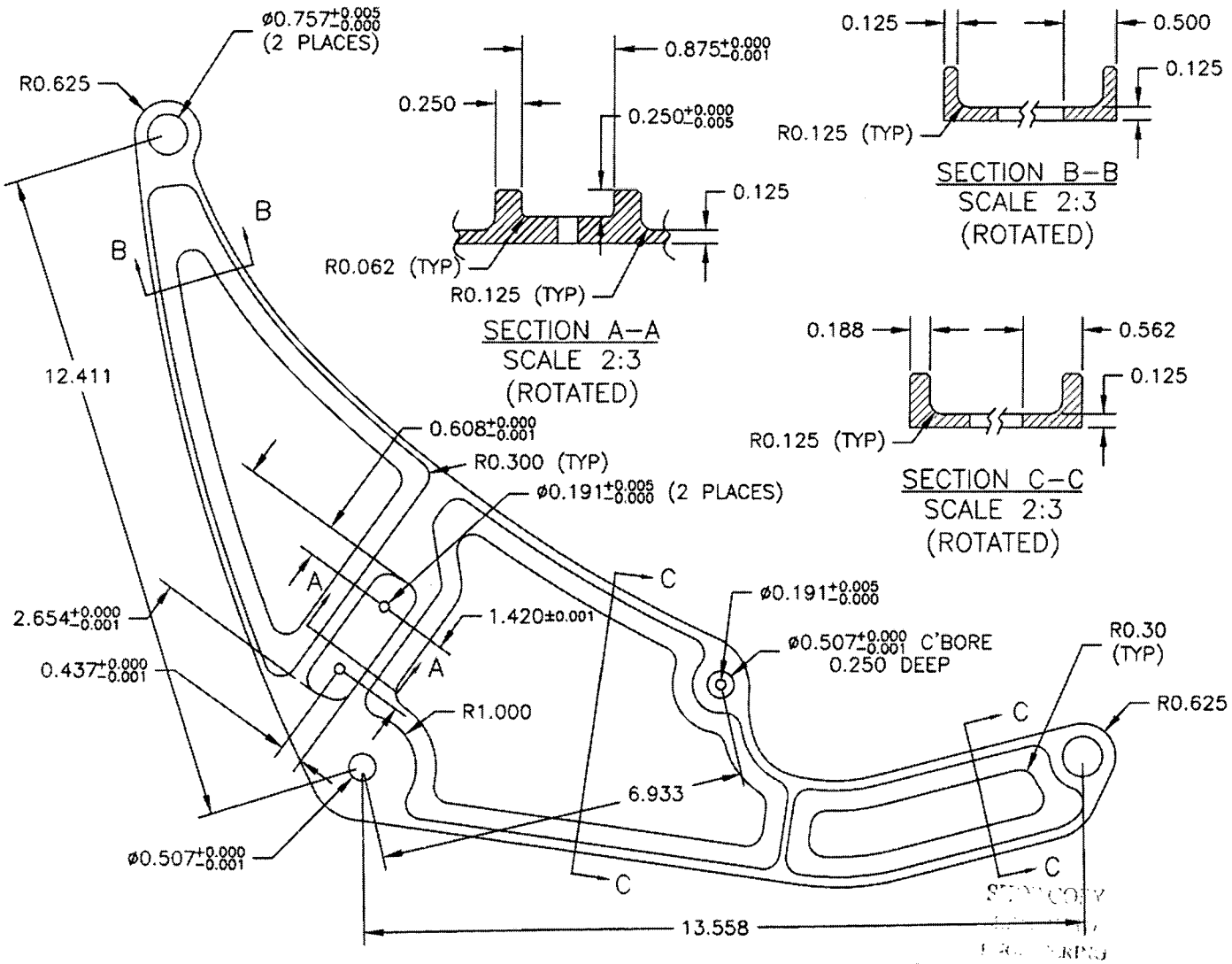
DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CP	CP		
CHECKED	APPROVED	DRAWING NO.	REV. B
		D2803	SHEET 1 OF 2
DATE		TITLE	SCALE
04.11.22		STA 84 BRACKET	1:3

A	00.11.07	NEW ISSUE
B	04.11.22	ADD CUTOUTS & −043/−044

RELEASED
05-03 11



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SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER
NO. 0010-73

PH 10-9-16

D2803−1 BRACKET (SHOWN), D2803−2 BRACKET (OPPOSITE)

1) MACHINE PER DRAWING FILE "D2803.SLDPRT"
2) MATERIAL: 6061−T6 (QQ−A−200/8) OR (QQ−A−250/11) 0.500 THICK
3) DEBURR TO LEAVE R0.030 − 0.063 ON ALL EDGES
4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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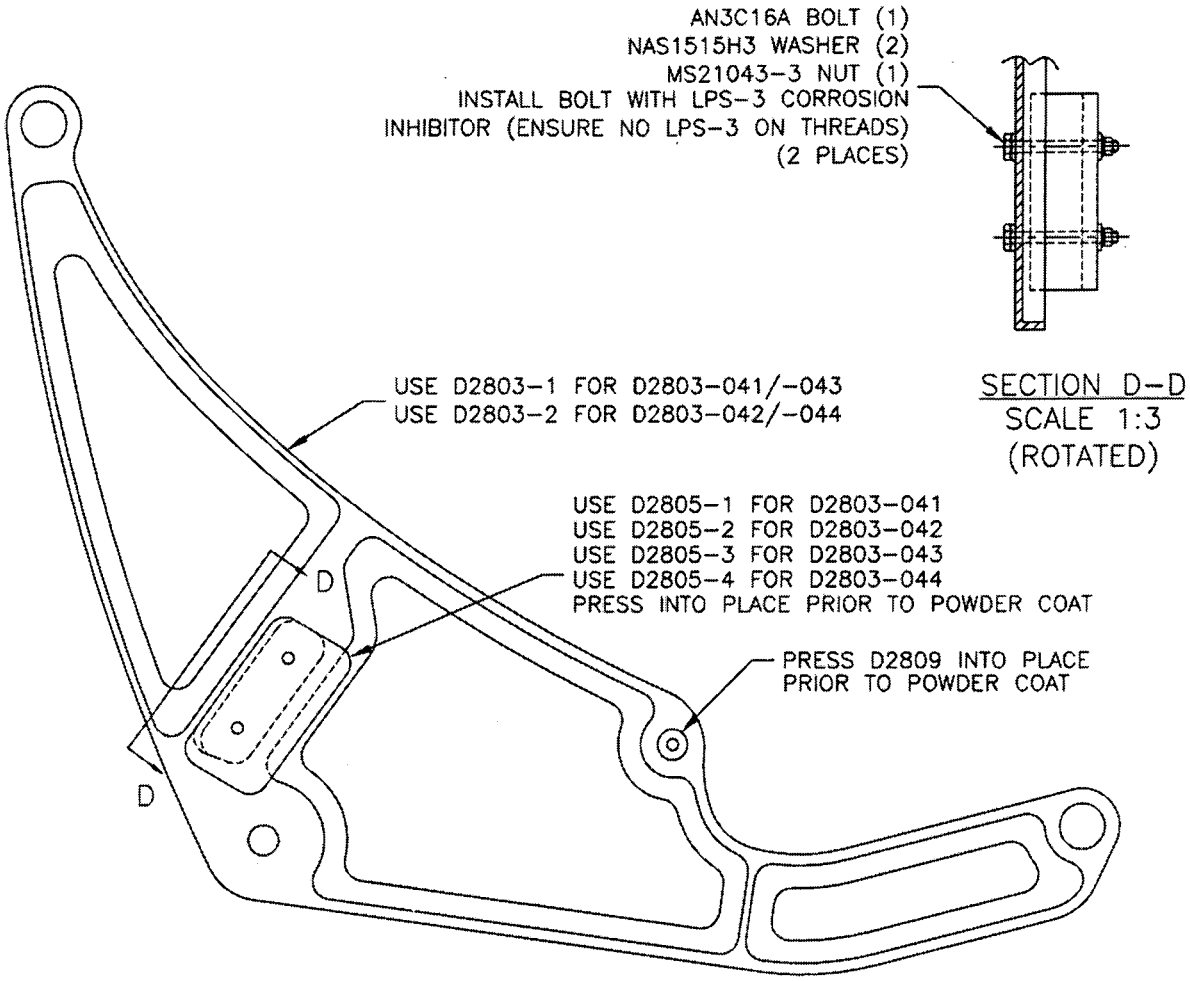
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CP	CP		
CHECKED	APPROVED	DRAWING NO.	REV. B
		D2803	SHEET 2 OF 2
DATE		TITLE	SCALE
04.11.22		STA 84 BRACKET	1:3

w/o 42073



RELEASED
05.03.11

D2803-041/-043 BRACKET ASS'Y (SHOWN).
D2803-042/-044 BRACKET ASS'Y (OPPOSITE)

6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6) OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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